

Work Order ID 52481

September 25, 2009 1:50:01 PM



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Item ID: PB67-43001-254
 Revision ID: B1C per ECN 09-678
 Item Name: Gusset

Accept



Setup Start



Stop



Start Date: 09/29/2009 Start Qty: 12.00
 Required Date: 10/08/2009 Req'd Qty: 12.00



Cust Item ID:
 Customer:

Reference:

Approvals: Process Plan: MF Date: 09-09-29 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
B67-43001	C

PD -7

100 FLOW WATER JET 0.00



Waterjet

Memo 0.00

FLOW CNC Waterjet

I-Cut as per Dwg B67-43001 ☐ Dwg Rev: C ☐ Prog Rev: C ☐ 2-
 Deburr if necessary

RB 9-9-29

110 QC2- Inspect parts off machine FAI/FAIB 0.00



QC

Memo 0.00

Quality Control

RB 9-9-29

120 QC8- Inspect parts - second check 0.00



QC

Memo 0.00

Quality Control

27 8/21/09/29

counters
(+30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: PB67-43001-254 PAR #: _____ Fault Category: Small Pub NCR: Yes ☒ No ☐ DQA: / Date: 09.10.13

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 52481		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/9/29	#100	Round parts with out notch cut in them. R.C. program wound up dated to Ecn 09-678	09/09/29	Parts are acceptable with out notch. this one time only update program for water Jet and PAI sheet.	09/09/29	09/09/29	09/09/29	09/09/29

NOTE: Date & initial all entries

Work Order ID 52481

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Item ID: PB67-43001-254

Accept



Setup Start



Revision ID: B1

Stop



Item Name: Gusset

Start Date: 09/29/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 10/08/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Packaging Packaging	Identify as per dwg & Stock Location: <u>W4</u> Memo	0.00 0.00	1209100 1209.10.01			30	0		
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

09/10/05 *AG*

RL 09-10-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 52481



Parent Item: PB67-43001-254RevB1



Parent Item Name: Gusset



Start Date: 09/29/2009

Required Date: 10/08/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	113.0104	0.8387	2.000		
												
6061-T6 .125 Sheet												139-9-29

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

113.0104

110062

1.85

111642

19.592

112476

32

112567

59.5684

112 567

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

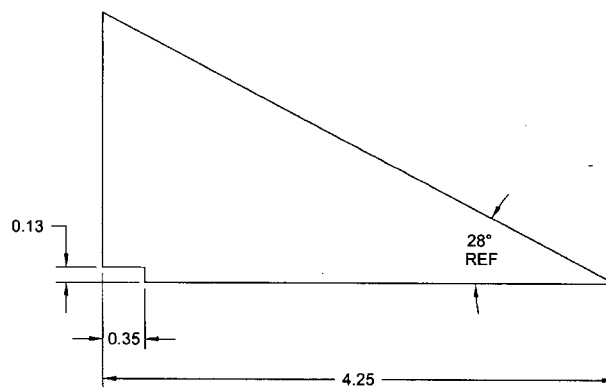
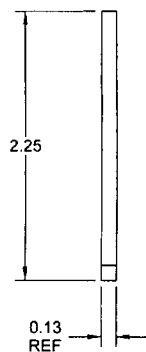
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



B67-43001-254 GUSSET

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF. DART SPEC. M6061T6S.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.06 lbs

RELEASED
2009-09-24
MD

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 23 OF PREMIER AVIATION DRAWING NO. B67-43001. REASON: SEE PAR#08-011.		MB	09.03.10
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD		
DRAWN		HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>MD</i>	DRAWING NO.	REV. C	
MFG. APPR.	<i>MD</i>	B67-43001-254	SHEET 1 OF 1	
APPROVED	<i>MD</i>	TITLE	SCALE	
DE APPR.	N/A	GUSSET	NTS	
DATE	09.03.10		<small>COPYRIGHT © 1985 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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